

SPUT

Date: Wednesday, 1/23/2008 12:06:17 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36941 2
Estimate Number : 13028
P.O. Number :
This Issue : 1/23/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL / MED FAB
Previous Run : 35707
Written By : [Signature]
Checked & Approved By : [Signature]
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC
Est Rev:B ECN 1113P 08-01-22 DD

Drawing Name : WELDMENT TOP PANEL
Part Number : D36501
Drawing Number : D3650 REV.B UAT Prelim
Project Number : N/A
Drawing Revision : B UAT Prelim
Material :
Due Date : 2/29/2008 Qty: 2 Um: Each



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 1.6622 sf(s)/Unit Total: 3.3243 sf(s)
304/316 SS sheet 26 ga (0.018" thick)
Batch: 106946 B 8-2-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3650
Dwg Rev: B B 8-2-4
Prog Rev: B
2-Deburr if necessary B 8-2-4



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

508/02/04 (2)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Form as per Dwg D3650

B 08-03-12 (2)

6677445227

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 36941

Part Number: D36501

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/17 @

7.0

MS20427M33

Rivet



Comment: Qty.: 18.0000 Each(s)/Unit Total: 36.0000 Each(s)

Rivet

batch: M106780

08-03-12

8.0

MS210603K

Nut Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut Plate

batch: M105935

M106966

08-03-12

9.0

MS210623K

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut Plate

batch: M105935

08-03-12

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3650

08-03-12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

08-03-13

S 08/07/17 @

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

S 08/07/17 @

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

POSITIVE RECALL

EFFECTIVE 08-01-13 AUTH

08/07/17

Job Completion

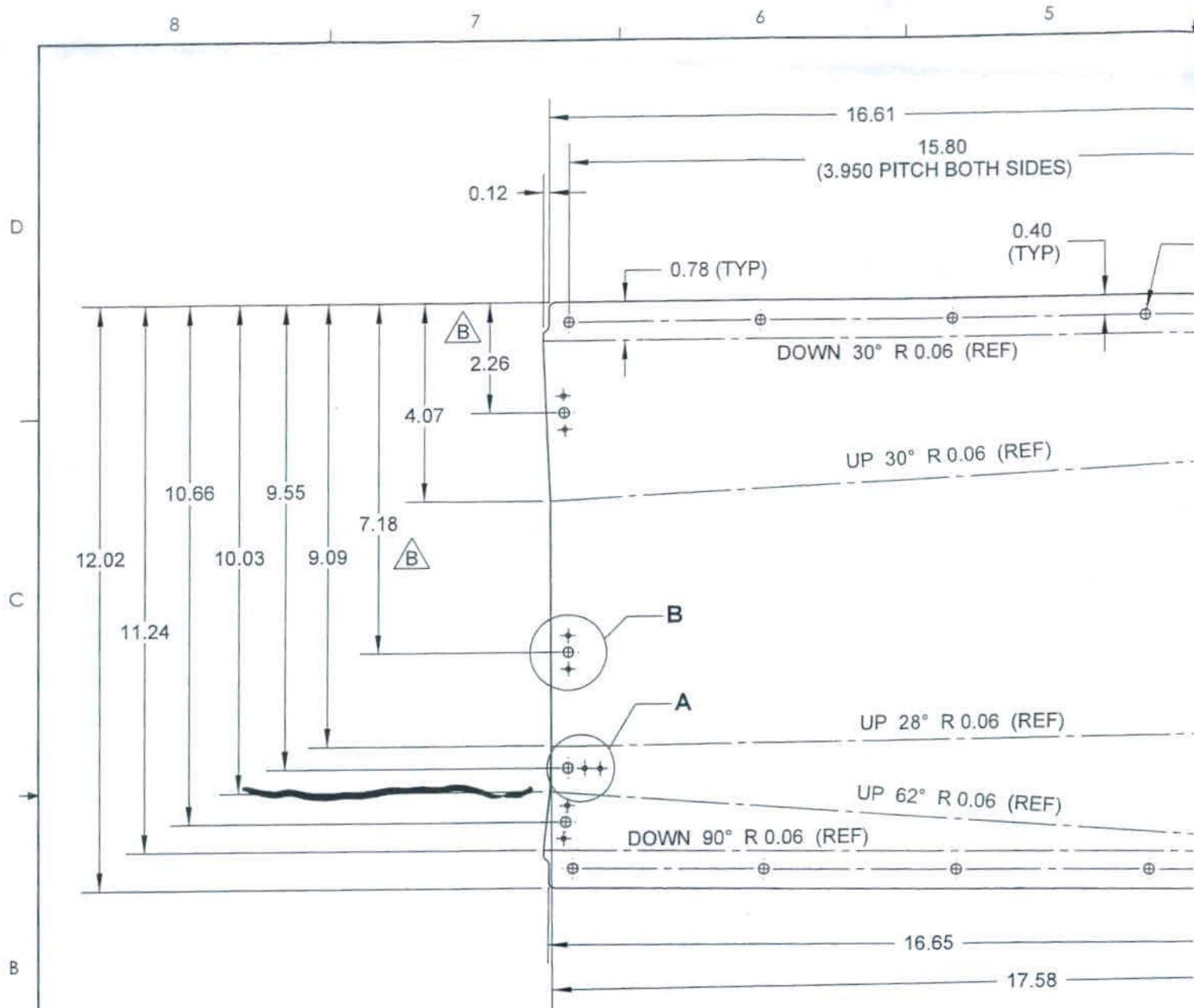


RELEASED

DATE

08/07/17

mf 08-07-17

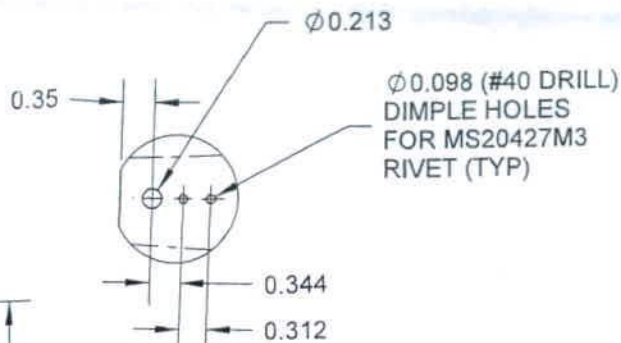
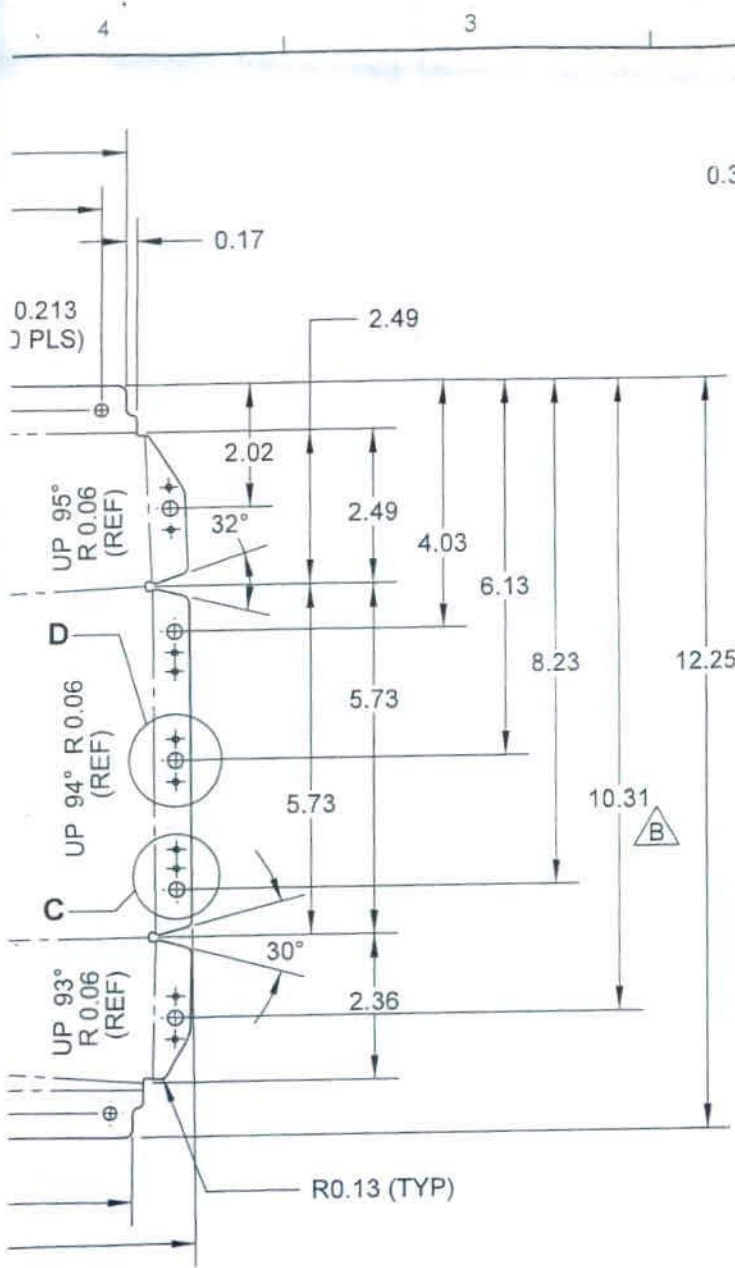


D3650-1F FLAT PATTERN

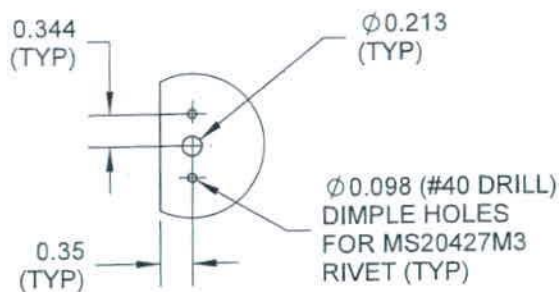
Ø 0.098 (#40 C
DIMPLE H
FOR MS204
RIVET

NOTES:

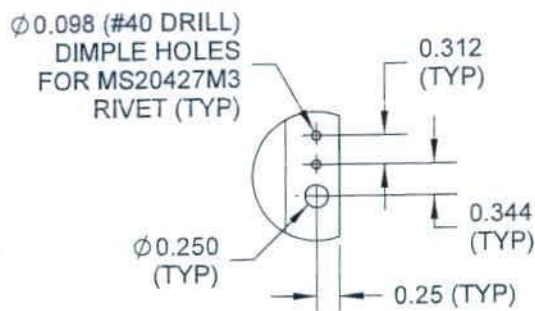
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs



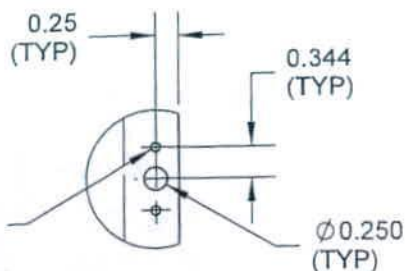
DETAIL A



DETAIL B



DETAIL C

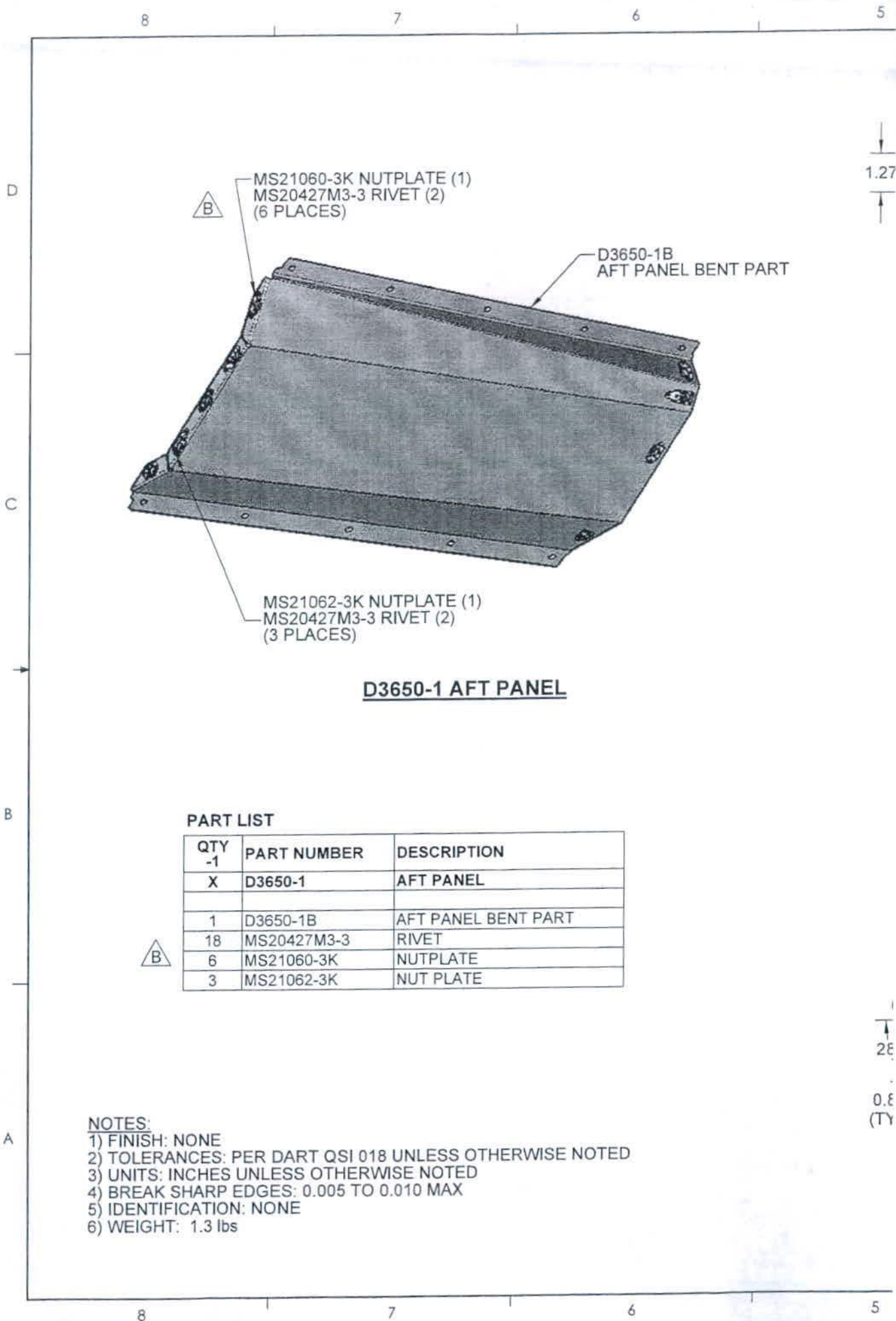


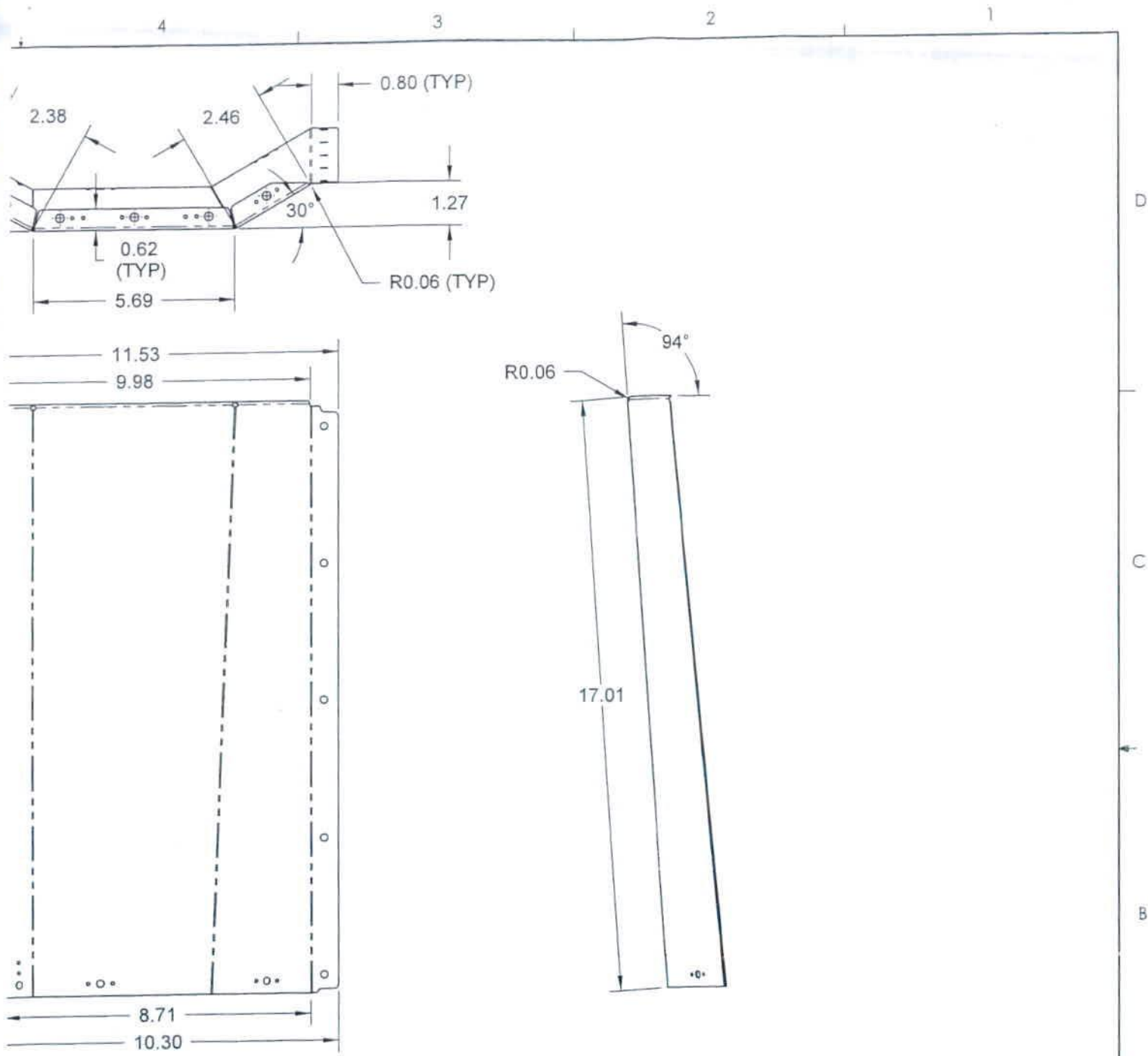
DETAIL D

PRELIMINARY ISSUE

08.01.18

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3650	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
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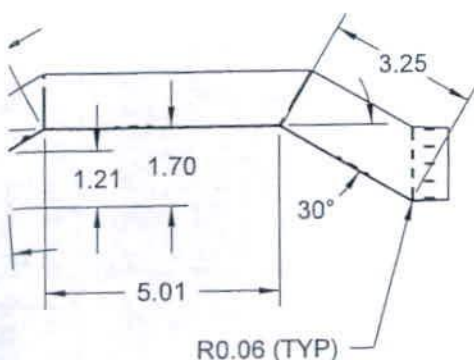




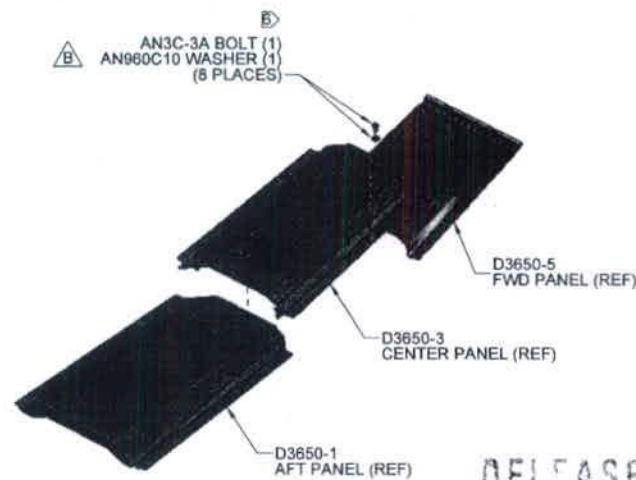
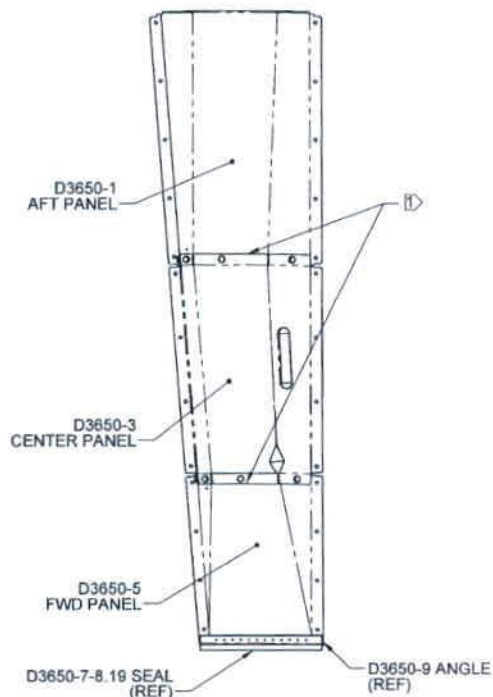
D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

PRELIMINARY ISSUE

UE 08.01.07



DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UE	DRAWING NO. D3650	REV. B
MFG. APPR.	MA	SHEET 2 OF 9	
APPROVED	W/O	TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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RELEASED
08-03-27/10

PART LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

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WORK ORDER
NO 3614-2

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5, 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOFF TO D3650-3F; MOVED D3650-11/11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11/11F FROM SHEET 6; UPDATED DIMS OF D3650-11/11F		RF	08.01.07
	A	NEW ISSUE	RF	07.11.07
REV	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	LE	DRAWING NO.	REV. B	
MFG. APPR.		D3650	SHEET 1 OF 9	
APPROVED		TITLE	SCALE	
DE APPR.		TOP PANEL ASSEMBLY	1:8	
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MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(6 PLACES)

D3650-1B
AFT PANEL BENT PART

MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(3 PLACES)

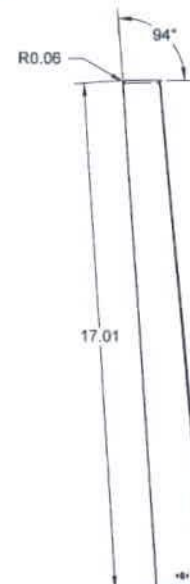
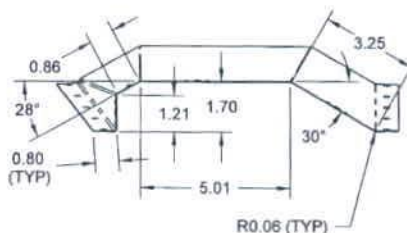
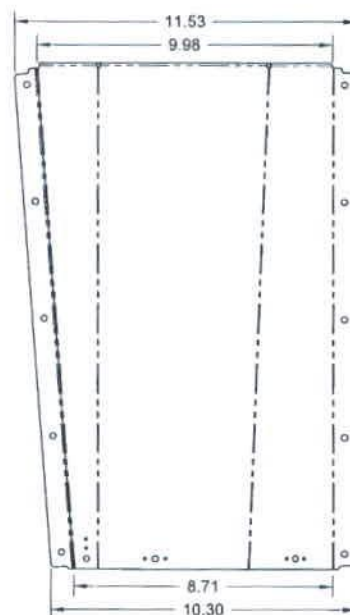
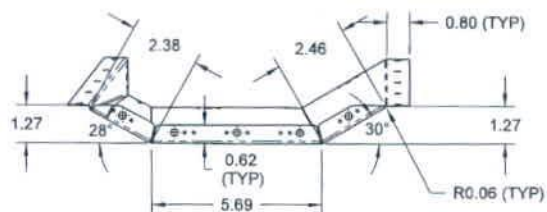
D3650-1 AFT PANEL

PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs



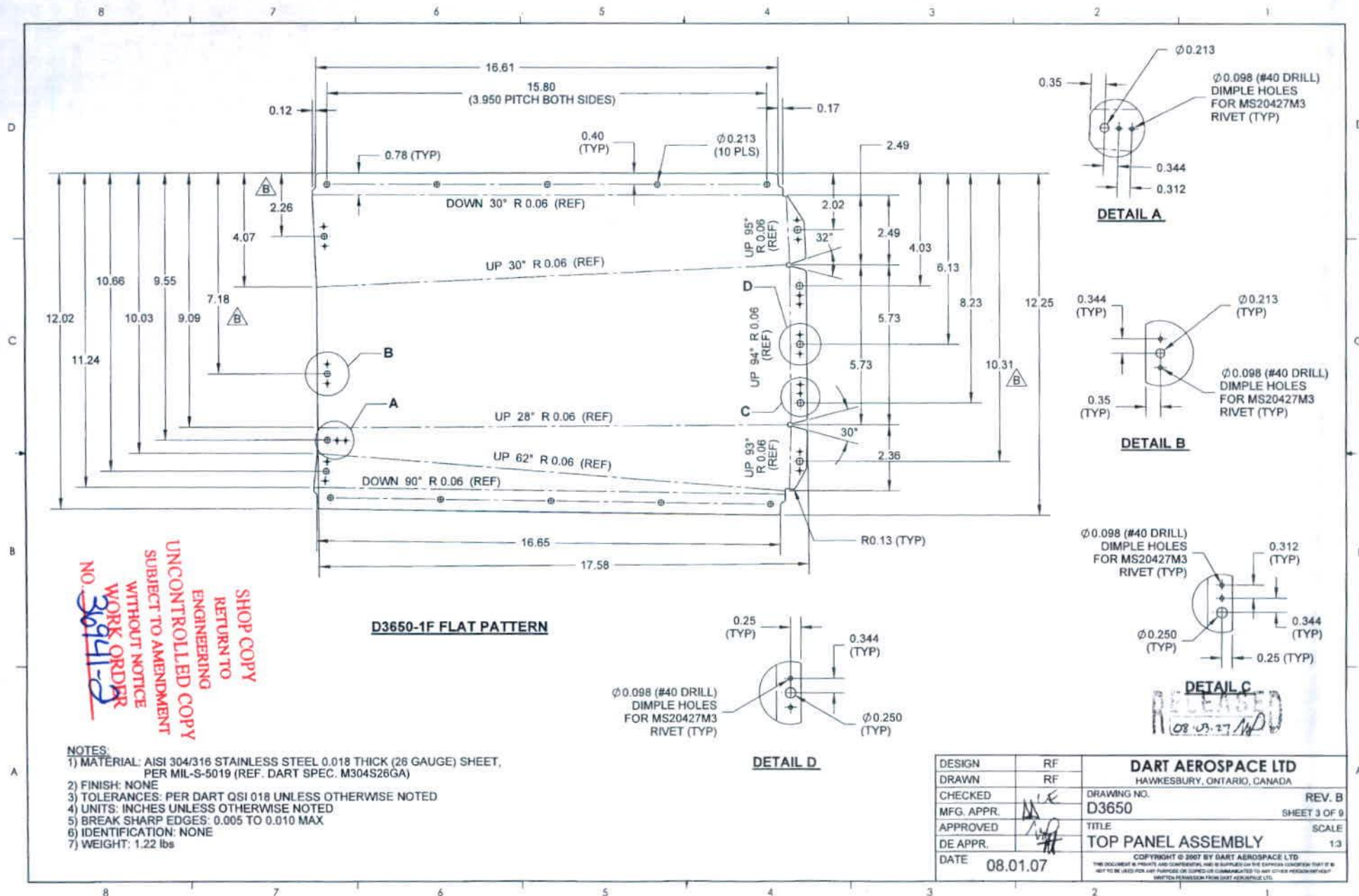
D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

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08.03.27

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED		D3650	SHEET 2 OF 9
MFG. APPR.		TITLE	SCALE
APPROVED		TOP PANEL ASSEMBLY	1:4
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DATE	08.01.07		

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PART LIST

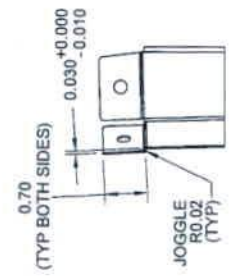
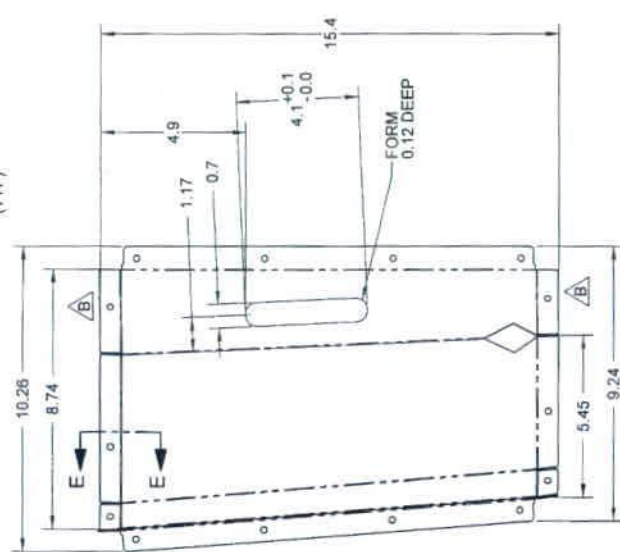
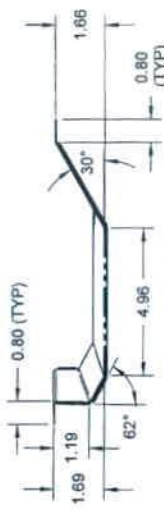
QTY	PART NUMBER	DESCRIPTION
3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

RELEASE
08-03-27 15A

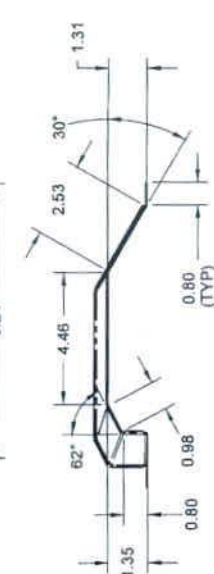
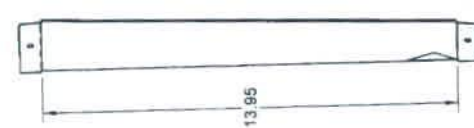
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.0 lb
8) TRIM D3850-11 TO FIT AS REQUIRED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
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10-10-60
10-11-60
10-12-60
10-13-60
10-14-60
10-15-60
10-16-60
10-17-60
10-18-60
10-19-60
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10-21-60
10-22-60
10-23-60
10-24-60
10-25-60
10-26-60
10-27-60
10-28-60
10-29-60
10-30-60
10-31-60



SECTION E-E



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NO. 36941-2

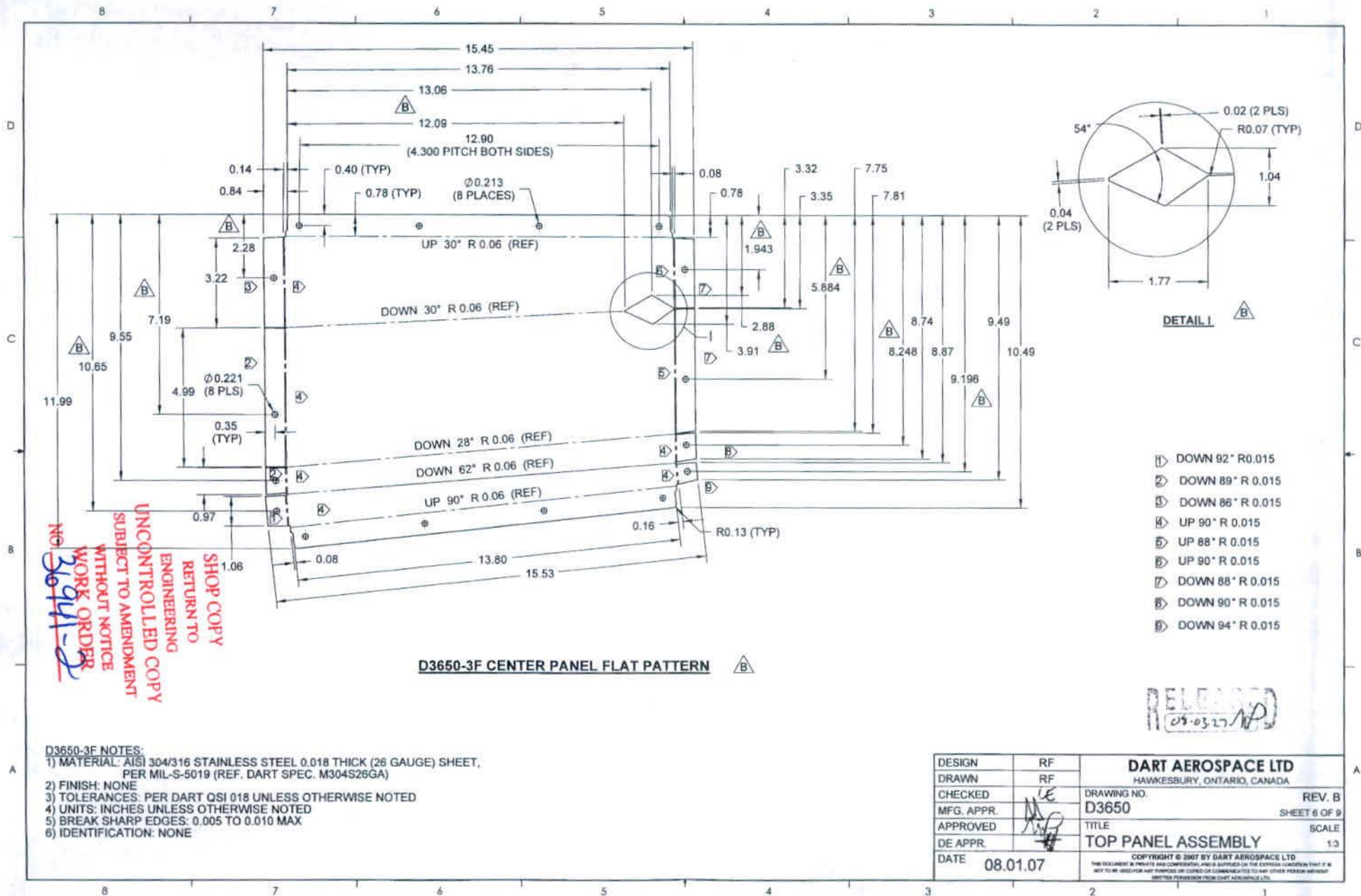
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO. D3650
MFG. APPR.		REV. B
APPROVED		SHEET 9 OF 9
DE APPR.		TITLE TOP PANEL ASSEMBLY
DATE	08.01.07	SCALE 1:4

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

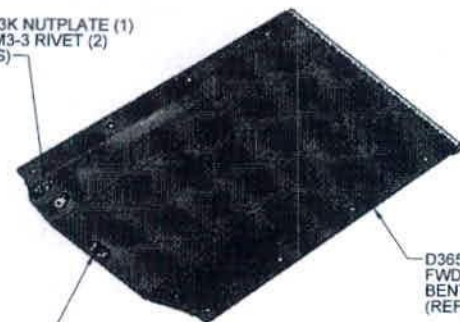
- NOTES:
- 1) FINISH: NONE
 - 2) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE

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08-03-27/10/07

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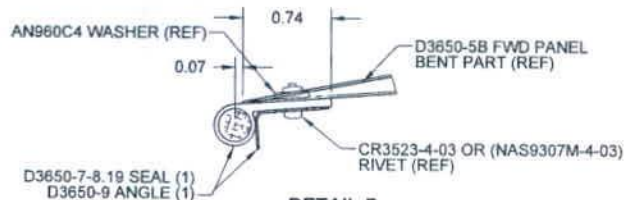


MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

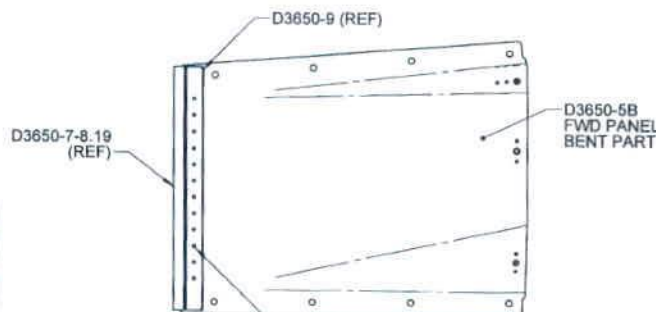
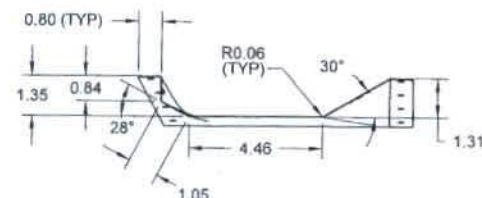


MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

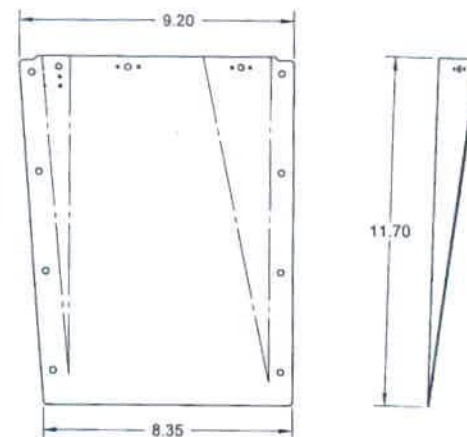
D3650-5B
FWD PANEL
BENT PART
(REF)



DETAIL F



CENTRE D3650-7-9 ON D3650-5B &
TRANSFER $\phi 0.129$ (#30 DRILL) HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)



D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

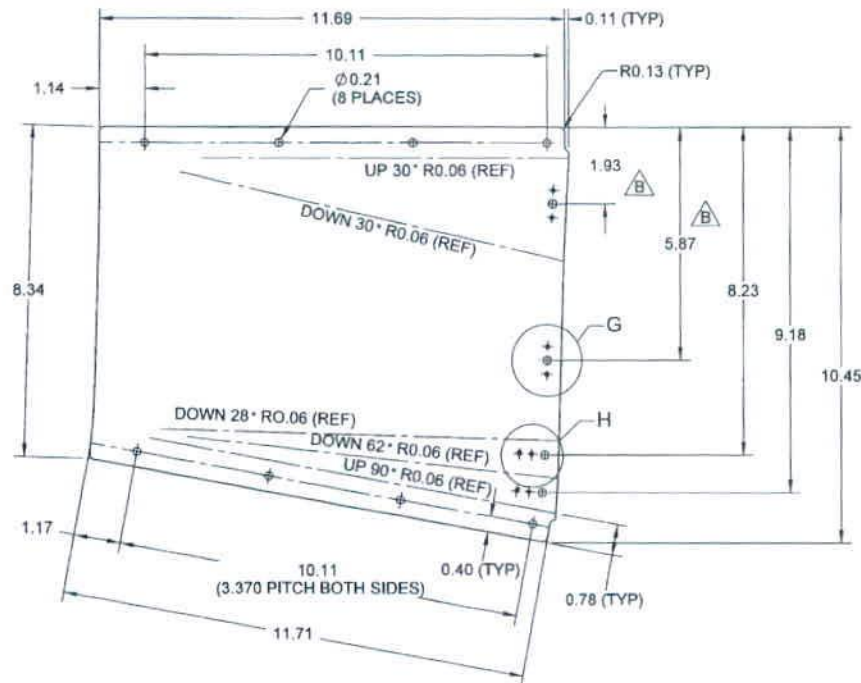
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lbs

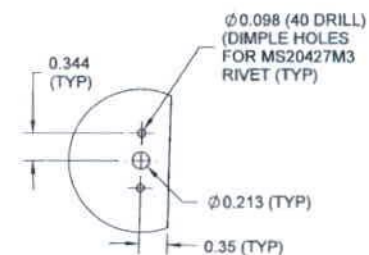
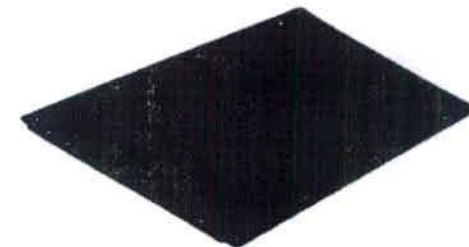
D3650-5 FWD PANEL

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	

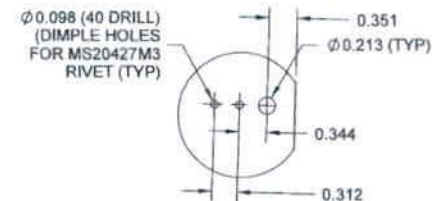
NO. 304-1-2
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D3650-5F FLAT PATTERN



DETAIL G
(2 PLS)



DETAIL H
(2 PLS)

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 WITHOUT NOTICE
 WORK ORDER
 NO. 36941-2

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO. D3650	REV. B
MFG. APPR.	DA	SHEET 8 OF 9	
APPROVED	DA	TITLE	SCALE
DE APPR.	DA	TOP PANEL ASSEMBLY	1:3
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